



Dart Aerospace Ltd.
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Canada

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D2121
Job Sheet 168862



Part No: D2121

Job Qty: 4 ea

Part Name: Clamp Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 12/10/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D IPP: D 04.05.27 Added Step 2-3; changed Step 4 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/9/17	12/9/17	0.00	0.00	Start Up Large Fab-1		DYC 17/11/27
100	Large Fab	4 pcs	12/9/17	12/9/17	0.00	1.42	Large Fab 1		DYC 17/11/27
110	QC	4 pcs	12/9/17	12/9/17	0.00	0.00	QC9		FF
120	Small Fab	4 pcs	12/10/17	12/10/17	0.00	2.90	Small Fab		FF
130	QC	4 pcs	12/10/17	12/10/17	0.00	0.00	QC5		38
140	Packaging	4 pcs	12/10/17	12/10/17	0.00	0.00	Packaging3	Stool	9-88
150	QC21-SA	4 Ea	12/10/17	12/10/17	0.00	0.00	QC21		17/12/11/27

Part Op 100 - Weld washer & wing nut as per Dwg D2121 & QSI 004 Identify as Wing Nut assembly
Descriptions: 120 - Assemble parts from steps 5-14 and Wing Nut Assembly as per Dwg D2121. Drill and deburr hole in coupling nut as per Dwg D2121. (Note: Install MS21042L4 Nut loosely) Cut D2771-BCFC-025-150 at 1.500"

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	5/16-18 SS WING NUT	4	0	0	0
	5/16WC	4	1,221	0	0
120-Small Fab	5/16-18 SS JAM NUT	4	39	0	0
	5/16-18 SS THREADED	4	13	0	0
	5/16-18SS1COUPLING	4	13	0	0
	AN4-4A	4	19	0	0
	D2012-107	4	8	0	0
	D2529	20	76	0	0
	D2771-BCFC-025-150	4	0	0	0
	D2771-LCC-025	4	0	0	0
	MS21042L4	4	914	0	0
	NAS1149D0463J	4	369	0	0

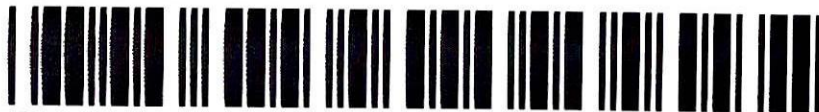
Part Specifications

Specifications could not be found.

Plex 11/23/17 2:24 PM dart.lacelle.linda

DART
AEROSPACE
S014224

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Clamp Assembly

PART NO: D2121

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/27/17

Job No: 168862

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

DAS
30
9-89

168862

C

5/16" WC SS WASHER

NOV 24 2017

5/16-18 WING NUT

5/16-18 THREADED ROD
6.5 LONG

- D2771-BCFC-025-150 SS BOLT (1)*
(CUT TO LENGTH AS REQUIRED)

D2529 SS WASHER (5)*

D

- D2771-LCC-025 SS LOCK NUT (1)*

*OR EQUIVALENT

5/16-18 JAM NUT

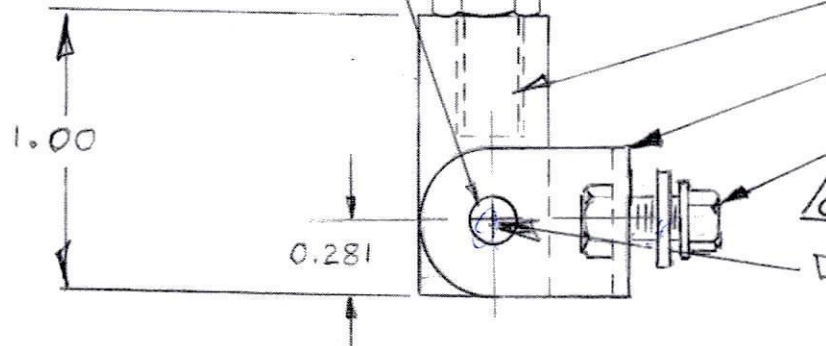
STAINLESS STEEL
5/16-18 1" COUPLING NUT
D2012-107 CLEVIS

AN4-4A BOLT

AN960JD416 WASHER

C MS21042L4 NUT, INSTALL LOOSE

DRILL THRU 1/4 (.250) DIA



RELEASED
04.05.04

COPY ISSUED

D	C	B	-	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
#	RF	RF	JB	DRAWN		BASIC CODE	DIA. DASH NO. W=HEAD NEAR SIDE F=HEAD FAR SIDE	CONTRACT NO.				
#	#	#	VE	APPROVED		0=DRIPLE DIOT=NO OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DATE				
04.04.15	03.01.17	03.01.17	03.01.17	DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		DESIGN				
					GENERAL	LIMITS	BASIC CODES		TITLE			
					1. DIMENSIONS ARE IN INCHES	1. TOLERANCES - JOK & .030	AL=MS20410AO BB=MS20426AO		CLAMP, BATTERY			
					2. SURFACE ROUGHNESS .125	2. ANGLES .002			DZ121			
					3. REMOVE SHARP EDGES .015 MAX	3. PARALLELISM .0025			D			
					4. THREADS PER INCH - 8 - 32	4. ECCENTRICITY .005 MAX			SCALE			
					5. HOLES PER AND 10287	5. SYMMETRY ABOUT ALL HVC CENTRE LINES .005			SHT 1 OF 1			
					REPORT ALL DISCREPANCIES - DO NOT SCALE							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									